

Work Order ID 140664

January 13, 2016 10:57:03 AM

140664

To ship Feb 1/16.

Page 1

Item ID: D429-793-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bearpaw

Stop

NS2

Start Date: 1/13/2016 Start Qty: 7.00

7

Cust Item ID:

Required Date: 2/1/2016 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals: Process Plan: SL Date: 20160113

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D429-793	C

DAS
6
9-89

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D429-793-011 CHG 003

DAS
27
9-89

X DAS
27
9-89

FEB 01 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
6
9-89

JAN 15 2016

DAS
28
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9-89

FEB 01 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Work Order ID 140664

January 13, 2016 10:57:03 AM

140664

Item ID: D429-793-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 1/13/2016 Start Qty: 7.00

7

Cust Item ID:

Required Date: 2/1/2016 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stam

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D429-793-011
LOCATION: FG015

7 DAS 27 FEB 01 2016 9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.01

Quality Control

MCS FEB 01 2016

MCS FEB 01 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Picklist Print

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Page 1

Work Order ID: 140664

140664

Parent Item: D429-793-011

D429-793-011

Parent Item Name: Bearpaw

Start Date: 1/13/2016

Required Date: 2/1/2016

Start Qty: 7.00

Required Qty: 7.00

Comments: Rev. A New Issue 10/10/18 DL IPP Rev. B
Change AN4C12A bots to AN4C13A bolts 10/11/05 DL IPP REV:C AS PER
ECN 11-580 JLM 10-05-24 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2274 *D2274* Radius Block		Manufactured	No			110	Each	281.0000	12	84			
									**			DAS 6 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				FG				12					
				86855				12					
				ST006				269					
				138998				269					
D3456-1 *D3456-1* Washer		Manufactured	No				Each	115.0000					
									**			DAS 6 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				FG				7					
				25701				7					
				ST038				8					
				135949				8					
				ST038A				100					
				136922				50					
				138961				25					
				140015				25					
D4176-1 *D4176-1* 429 Clamp, Top		Manufactured	No			110	Each	44.0000					
									**			DAS 6 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST544				44					
				133076				6					
				133810				38					

JAN 15 2016

Picklist Print

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Work Order ID: 140664

Parent Item: D429-793-011

Parent Item Name: Bearpaw

140664

D429-793-011

Start Date: 1/13/2016

Required Date: 2/1/2016

Start Qty: 7.00

Required Qty: 7.00

D4212-1

Manufactured No

Each

26.0000

42

DAS

6

DAS

28

9-89

~~D4212-1~~*

429 Clamp Cushion

68-6

LZ

SV

Location

Loc Qty

Loc Code

ST545

26

133077

16

133811

10

D4353-041

Manufactured No

Each

0.0000

14

DAS

6

DAS

28

9-89

~~D4353-041~~*

Bearpaw Assembly

D4354-041 27

9-89

~~D4354-041~~*

Bearpaw Wearplate Assembly

DAS

27

9-89

Location

Loc Qty

Loc Code

ST605

3

131260

2

135910

1

D4382-1

Manufactured No

Each

5.0000

14

DAS

6

9-89

DAS

28

9-89

~~D4382-1~~*

Angled Bearpaw Clamp

DAS

27

9-89

Location

Loc Qty

Loc Code

ST544

5

120516

5

JAN 21 2016

Picklist Print

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Page 3

Work Order ID: 140664

Parent Item: D429-793-011

Parent Item Name: Bearpaw

140664

D429-793-011

Start Date: 1/13/2016

Required Date: 2/1/2016

Start Qty: 7.00

Required Qty: 7.00

AN4C11A

Purchased

No

Each

54.0000

AN4C11A

bolt

DAS
27
9-89

70

Location

Loc Qty

Loc Code

ST312A

25

m132803

25

ST344

29

m131677

2

m131957

5

m132551

22

Each

39.0000

**

56

25

134023x3

DAS
6
9-89

DAS
28
9-89

AN4C16A

Purchased

No

AN4C16A

BOLT

DAS
27
9-89

70

Location

Loc Qty

Loc Code

ST343

39

m131886

39

Each

15.0000

**

56

134023

DAS
6
9-89

DAS
28
9-89

AN4C22A

Purchased

No

AN4C22A

BOLT

DAS
27
9-89

70

Location

Loc Qty

Loc Code

ST342

15

122800

5

m132823

10

**

28

134023

DAS
6
9-89

DAS
28
9-89

JAN 15 2016

Picklist Print

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Work Order ID: 140664

Parent Item: D429-793-011

Parent Item Name: Bearpaw

140664

D429-793-011

Start Date: 1/13/2016

Required Date: 2/1/2016

Start Qty: 7.00

Required Qty: 7.00

MS21043-4

Purchased

No

Each

1,175.000

30

140

MS21043-4

Nut

**

DAS

6

9-89

DAS
27
9-89

X7

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

267

m128798

5

m132803

262

OVER007

800

m133769

800

ST302

68

m133316

68

20x20 20

Each

2,751.000

12

84

NAS1149D0463J

Purchased

No

NAS1149D0463.1

WASHER

**

DAS

6

9-89

JAN 15 2010

DAS
27
9-89

X7

Location

Loc Qty

Loc Code

GA

397

M129390

41

M132035

356

ST260a

500

M133932

500

ST263

430

M133284

32

M133316

398

ST269

1424

M129682

39

M130799

361

M132317

101

M132677

888

M133077

35

DAS

28

9-89

January 13, 2016 10:57:09 AM

Shop Packet Print

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REFERENCE ONLY

DART AEROSPACE LTD.

IIIN-D429-793

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5.0 PARTS LIST

QTY -011	Part Number	Description
X	D429-793-011	ULTRAPAW™ INSTALLATION
12	D2274	RADIUS BLOCK
8	D3456-1	WASHER
4	D4176-1	CLAMP, TCP
6	D4212-1	CLAMP CUSHION
2	D4353-041	ULTRAPAW™ ASSY
2	D4354-041	WEARPLATE ASSY
2	D4382-1	ANGLED CLAMP
8	AN4C11A	BOLT
8	AN4C16A	BOLT
4	AN4C22A	BOLT
20	MS21043-4	NUT
12	NAS1149D0463J	WASHERS

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Revision: C
Date: 11.04.08